

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009129**Date Inspected:** 20-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen fu you**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

SEGEMENT

FCAW welding of weld joint 2F-013 located on PCMK CA52 of 8AE welder is identified as 066683.ZPMC QC is identified as Mr. Wang xian pin . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132-3.

BAY#14

FCAW welding of weld joint 3F-030 located on PCMK DP124-001 of 9CW welder is identified as 045175.ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

SAW welding of weld joint 1G-006 located on PCMK SEG073A-006 of 11EW welder is identified as 062406. ZPMC QC is identified as Mr.Zhang xian ji. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint 1G-002 located on PCMK SEG068A of 11BE welder is identified as 044771.ZPMC QC is identified as Mr.Tang ya jun. The welding variables recorded by QC appeared to Comply with the

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WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 1G-007 located on PCMK SSD11-PP75 of 9BW welder is identified as 202122. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

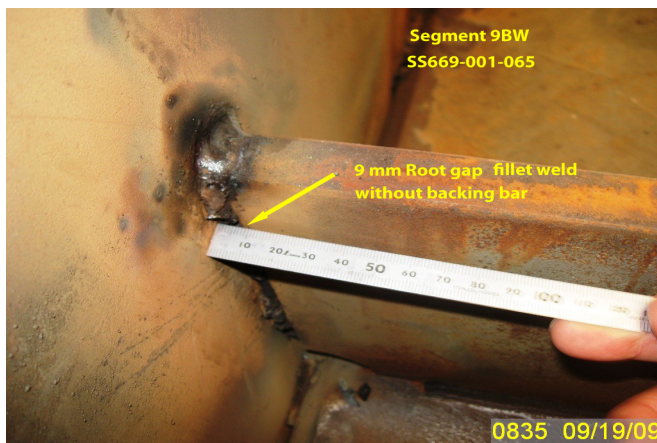
SMAW welding of weld joint 4G-020 located on PCMK SEG051A-020 of 9BW welder is identified as 045246. ZPMC QC is identified as Mr. Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

The following fillet weld joints having more than 5mm root gap but that welded one side without using backing bar, the weld nos are SP669-001-063,064,065 of 9BW informed to ZPMC QC Mr.Xuo tao and ABF QA Mr.Liu jin ping.

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Tower Lift 3. The weld designations reviewed are as follows:

ESTL3-4C/K-04,05.
ESTL3-4B/K-04,05.
ESTL3-4B/K-77,78.
ESTL3-4K/K-43,21,42,20,19,17.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Item	Description	WBS	Dwg No.	Status
1				

Summary of Conversations:

No Relevant Conversation.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar, Chadra	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
